

Date: Wednesday, 3/21/2007 3:49:05 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 31428	
Estimate Number : 10710	
P.O. Number : N/A	Part Number : D32111
This Issue : 3/21/2007 S.O. No. : N/A	Drawing Number : D3211 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 30899	Material : N/A
Written By : _____	Due Date : 4/4/2007 Qty: 10 Um: Each
Checked & Approved By : <u>07.03.22</u>	
Comment : Est Rev:A New Issue 05-11-17 JLM	
Est Rev:B Now on Waterjet 06-10-24 JLM	

Additional Product



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 1.4753 sf(s)/Unit Total : 14.7525 sf(s) 5.902
Material: 2024-T3 (QQ-A-250/4) 0.063" thick M103321^{x4} M102942^{x3} 4.4259
(M2024T3S.063) Identify as D3211-1
Batch: M101022^{v3} 4.4259 M 07 04 04

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3211
Dwg Rev: A1
Prog Rev: A1

M 07 04 04

(10)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 07 04 04

(10)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

224.09 (10)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr


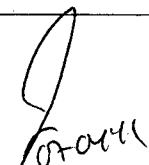
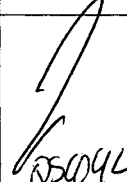
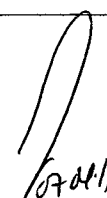
M.F. 07-04-11

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/11	6	2 piece material crack at the end		Scrap + destroy	SB 07/04/11			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31428

Part Number: D32111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

SK 07/04/11 (8) P12

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/12 (8)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 07-04-12 (8)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8X 07/04/12

10.0

POWDER COATING

POWDER COATING



M102361



(8X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

07/04/12

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/4/13 (8)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/13

Job Completion



U 07.04.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

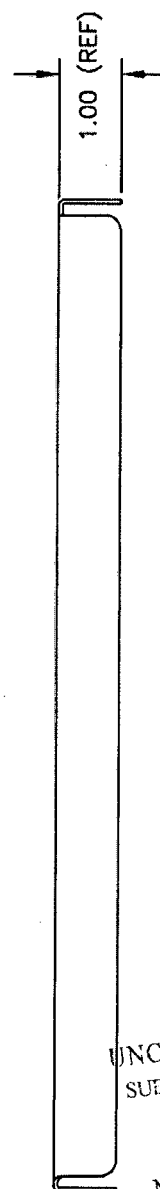
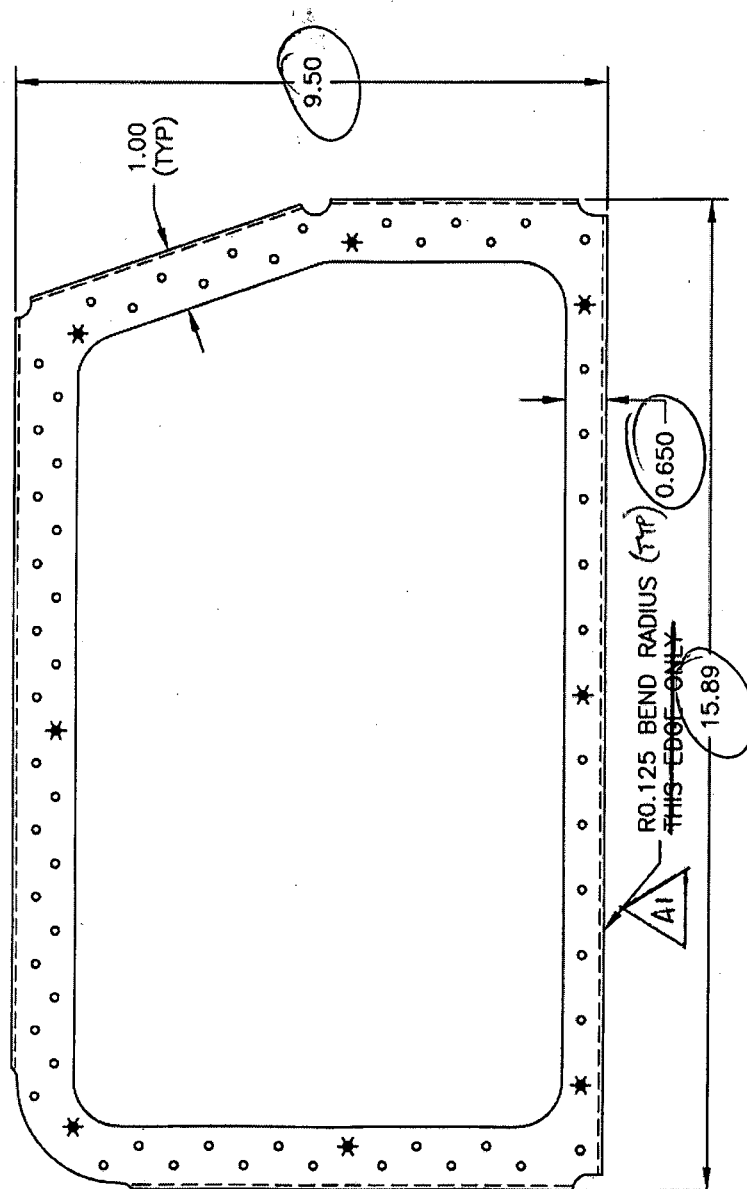
NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	APPROVED	[Signature]	DRAWING NO. D3211	REV. A SHEET 1 OF 2
DATE	03.09.03			TITLE BRACKET	SCALE 1:3
A	03.09.03			NEW ISSUE	
A1	[Signature] 03.12.05			CHANGE ALL BEND RADII TO R0.125	

RELEASED
03.09.15

D3211-1 BRACKET
MACHINE PER DRAWING FILE "D3211-A2.DWG"
CHECK PER TEMPLATE D3211-1T1
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
USE MINIMUM BEND RADIUS OF $\phi 1.88$, EXCEPT WHERE INDICATED $\phi 0.125$
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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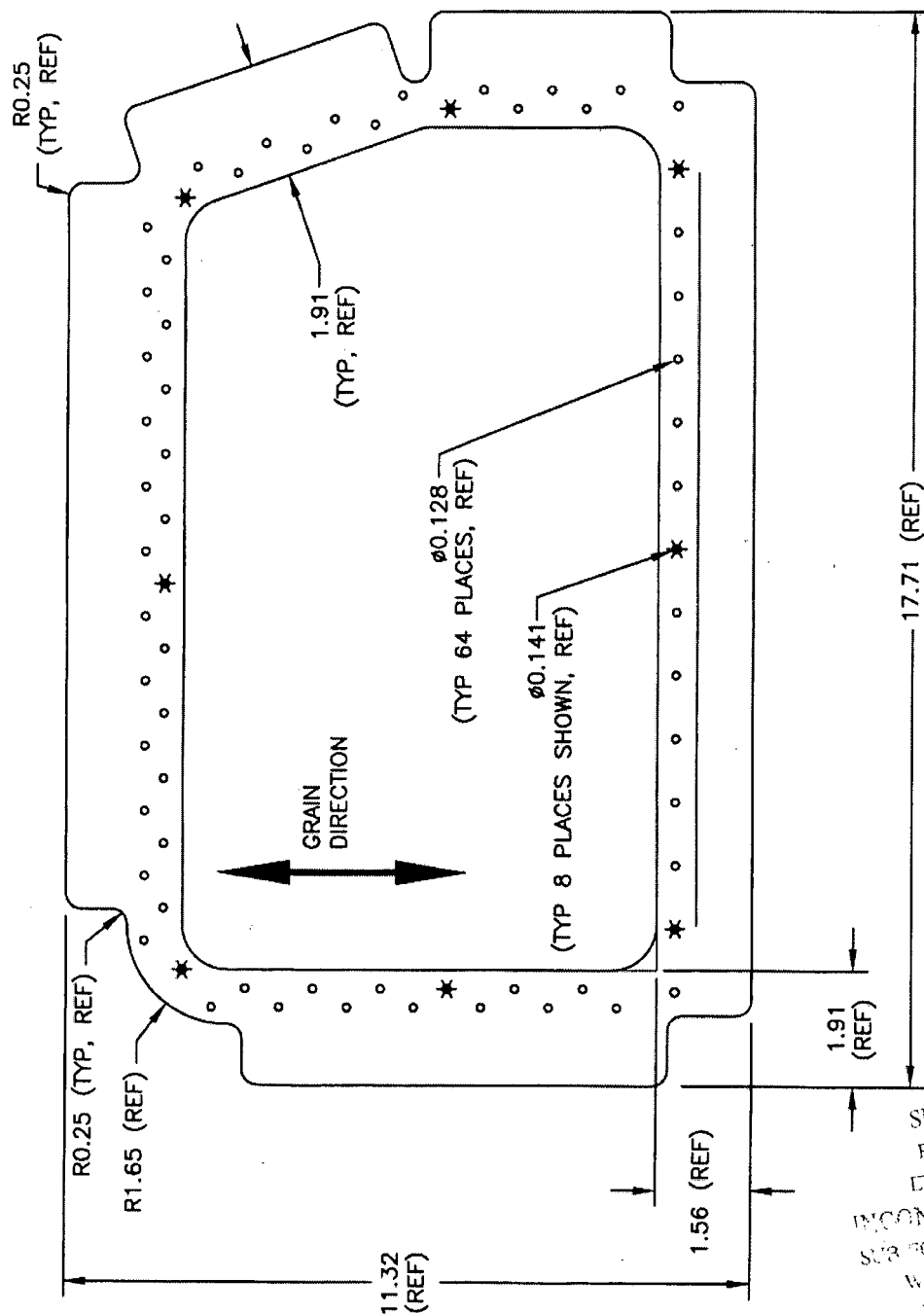
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DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3211	REV. A SHEET 2 OF 2
DATE 03.09.03	TITLE BRACKET		SCALE 1:3

RELEASED
03.09.15

D3211-1 FLAT PATTERN



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